

Date: Thursday, 6/22/2006 8:41:58 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET (A119) ARMS
<b>Job Number</b> : 27660	
<b>Estimate Number</b> : 12437	
<b>P.O. Number</b> :	<b>Part Number</b> : D35181
<b>This Issue</b> : 6/22/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D3518 PRELIMINARY
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : NIA <b>Type</b> : R & D SM/MED FAB	<b>Drawing Revision</b> : A PRELIMINARY
<b>Previous Run</b> : NIA	<b>Material</b> : NIA
<b>Written By</b> : <u>SPC COMMENT BELOW</u>	<b>Due Date</b> : 6/23/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>W</u>	
<b>Comment</b> : EST rev. A 05.06.06 preliminary EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0875X06000	6061-T6 Bar 875" x 6.0"
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**Comment:** Qty.: 0.1400 f(s)/Unit Total : 0.2799 f(s)  
 6061-T6 Plate .875" x 6.0"  
 (M6061T6B0875X06000)  
 Batch: 1161323

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3518

Dwg Rev: PreliminaryProg Rev: Preliminary

2-Open holes to finish size as per Dwg D3518

3-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

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Part Number: D35181

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/07/17 SAE

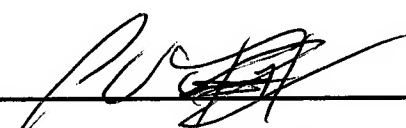
8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 



9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.18

Job Completion

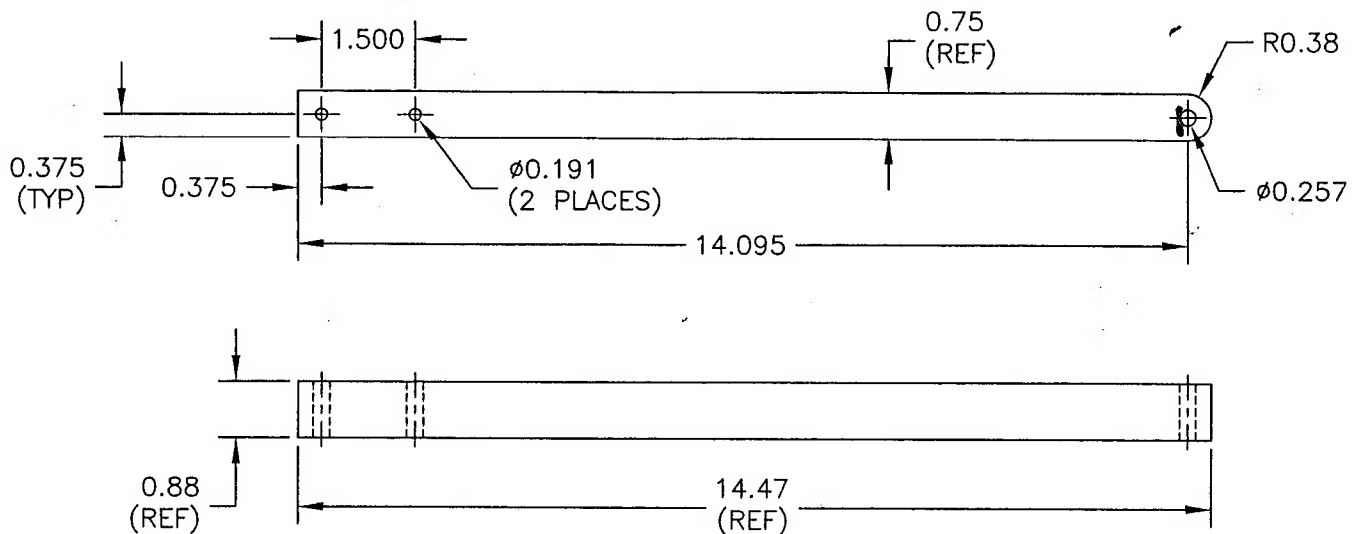


06.07.17

**PRELIMINARY ISSUE**

06.06.22

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3518	REV. B SHEET 2 OF 2
DATE 06.06.21		TITLE BASKET (A119) STRUT	SCALE 1:3



2x

**D3518-1 STRUT**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
06-06-22

**NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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